

Date: Friday, 13/06/2008 2:46:01 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DRAIN TUBE ASSEMBLY
<b>Job Number</b> : 39878	
<b>Estimate Number</b> : 12623	
<b>P.O. Number</b> :	<b>Part Number</b> : D2127251915
<b>This Issue</b> : 13/06/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D212-725-1 PG29
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 30990	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 19/06/2008
<b>Checked &amp; Approved By</b> : JLD 08.10.13	<b>Qty</b> : 4 2 Um: Each 2
<b>Comment</b> : Est Rev:A New Issue 07-01-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 3.3000 f(s)/Unit Total: 6.6000 f(s)

304 SS .750" X .049" WALL

Batch: 11107998

FF 08-06-18

(2)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form tube as per Dwg D212-725-1 & DT8909 Template

FF 08-06-18

(2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

u/a Done out 30955

Sosloc 12/19  
08/06/19

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0	AN81812J	Nut
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M1238

SB 08/06/19

Dart Aero

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 2:46:01 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 39878

Part Number: D2127251915

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS2081912J

Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Batch:

M 819

M 103177

(2)

8B 08/06/19

(2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install sleeves & nut then flare tube as per Dwg D212-725-1.

FF 08-06-19

(2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-10-28

(2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

U 08-10-29

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

(2)

Job Completion



U 08-10-29

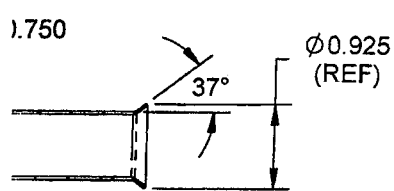
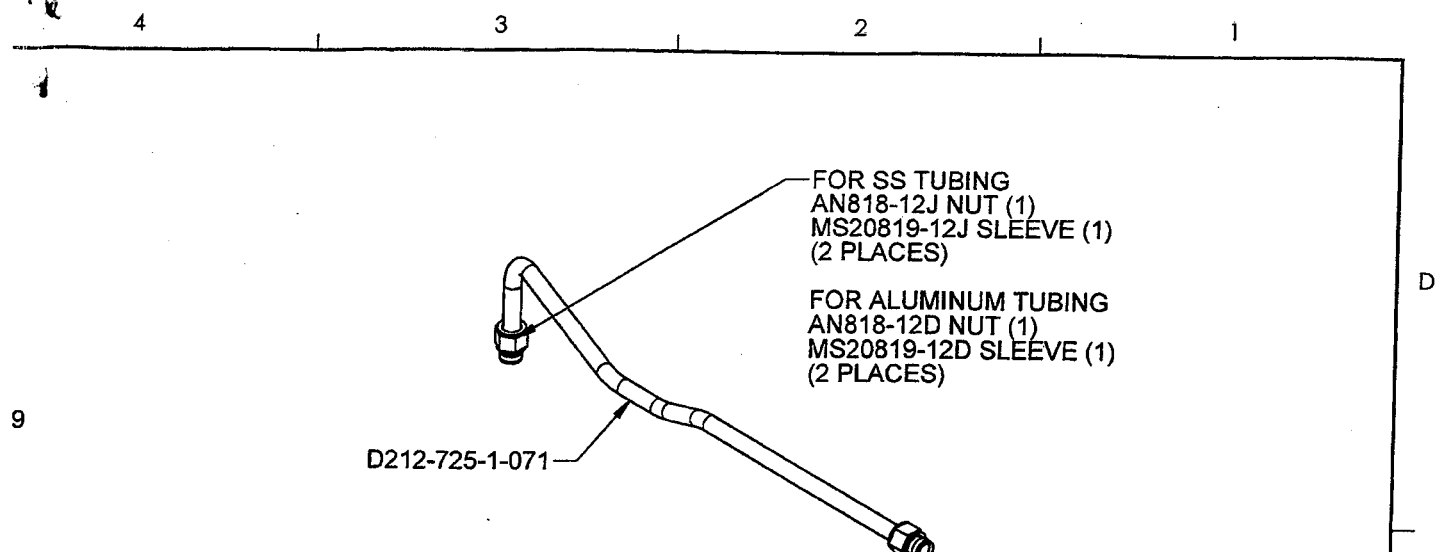
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

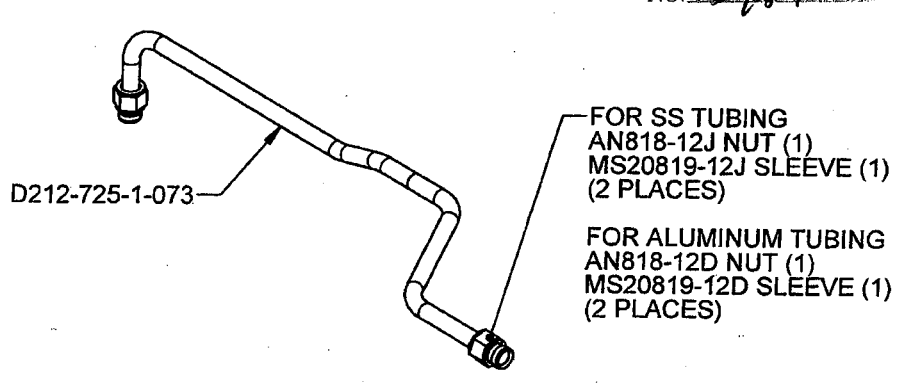
NOTE: Date & initial all entries




SECTION K-K  
FLARE ONE END  
(FOR ASSEMBLY)  
SCALE 1:2

**D212-725-1-913 DRAIN TUBE ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391878



**D212-725-1-915 DRAIN TUBE ASSY**

B	07.05.11	ADD NOTE FABRICATE FROM SS	
A	06.12.08	NEW ISSUE	
DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED 	DRAWING NO. <b>D212-725-1</b>	REV. B SHEET 28 OF 44
DATE <b>07.05.11</b>	TITLE <b>212S DETAIL PARTS</b>		SCALE 1:8
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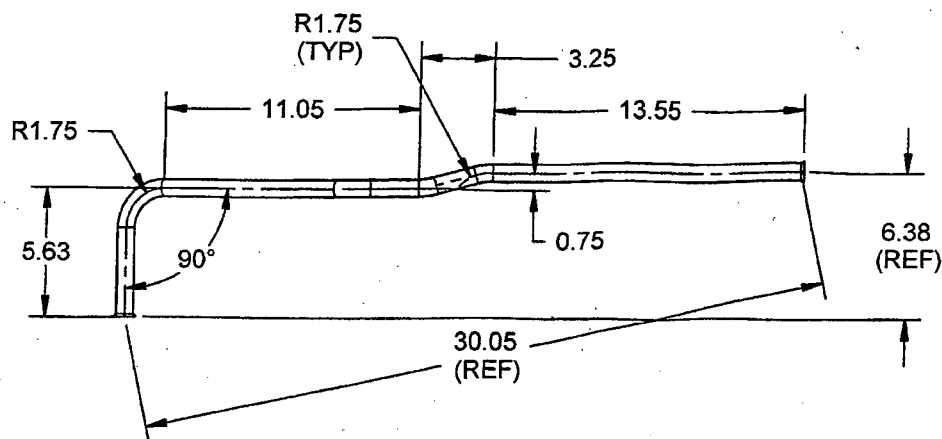
8

7

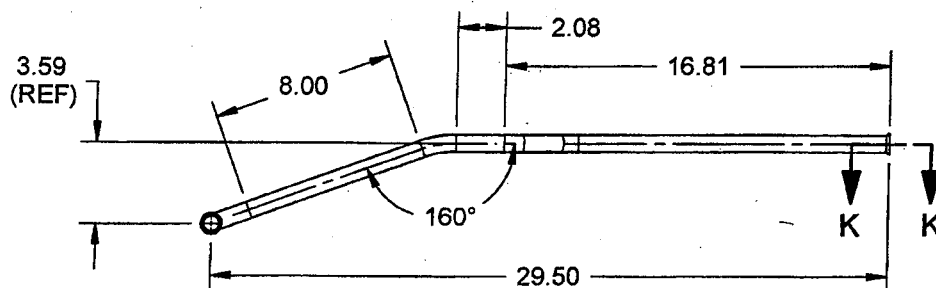
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5

D

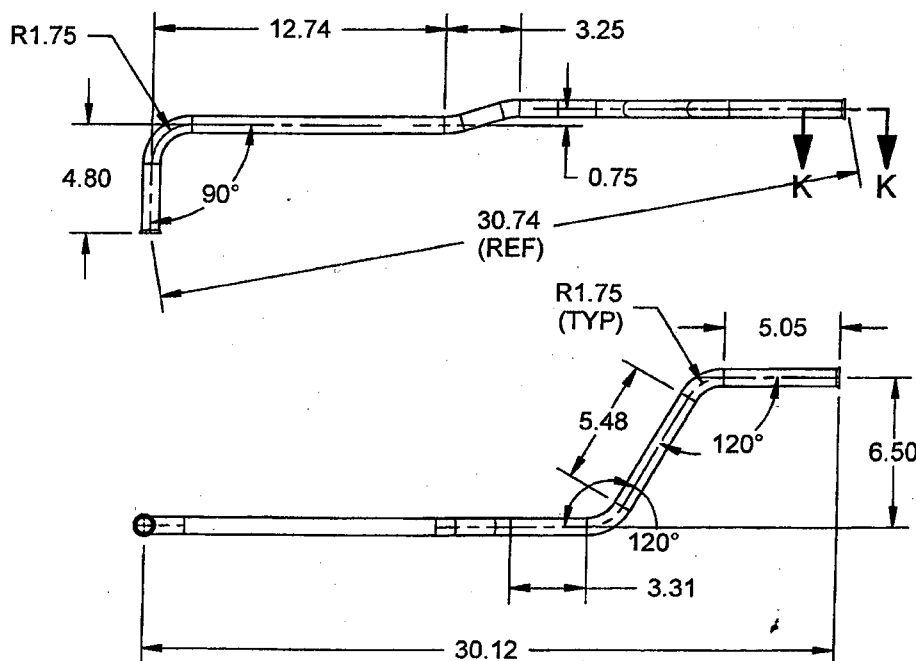


C



**D212-725-1-071 DRAIN TUBING**  
MANUFACTURE PER TEMPLATE DT8908

B



**D212-725-1-073 DRAIN TUBING**  
MANUFACTURE PER TEMPLATE DT 8909

A

**D212-725-1-071/-073:**

- 1) MATERIAL: AISI 304/316 SS  $\varnothing 0.750 \times 0.049$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.750W.049) OR 6061-T6 OR 6061-T62 ALUMINUM TUBING  $\varnothing 0.750 \times 0.035$  WALL (REF. DART SPEC. M6061T6TR0.750W.035)
- 2) FINISH: FOR ALUMINUM TUBING ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY (-913/-915) WITH DART P/N USING FINE POINT PERMANENT INK MARKER

8

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